

# Work Order ID 75345

**\*75345\***

Page 1

October-21-11 8:02:48 AM

Item ID: D350-636-015

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube STD w/ Training Wearplates, LH

Stop **\*NS2\***

Start Date: 20/10/2011 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals; Process Plan: MLJ Date: 11/10/21 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3492	C								
D4168	A								
IIN-D350-636	I								

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-015 CHG 002

*8/11/25*

*OK 11/11/25 per MSL*

**75345**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 75345****\*75345\***

Page 2

Item ID: D350-636-015

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
<b>*110*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr, section H-H								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section H-H								
	5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168, detail A								
	6- Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.								
	9-Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side) open holes of detail D section H-H to 0.500" as per dwg D4168								
	10-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

Dk. 11/11/15.

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Work Order ID 75345

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Page 3

October-21-11 8:02:48 AM

Item ID: D350-636-015

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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A/R Aluminum Rod batch: *M11835 BE 11-11-15*

11-Grind welds flush as per Dwg D4168

*DD 11-11-16*

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*Sulu/17*

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

*Sulu/17*

*(70)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Page 4

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**Work Order ID 75345****\*75345\***

Page 5

October-21-11 8:02:48 AM

Item ID: D350-636-015

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube STD w/ Training Wearplates, LH

Stop **\*NS2\***

Start Date: 20/10/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
<b>*160*</b>									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling section AL-AL to 0.625" (total of 8 holes per side) as per dwg D4168.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D4168.								
	3- Open float hole to 0.500" (4 per side) section AJ-AJ								
	Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG								
	4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes section AJ-AJ per dwg D4168 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>19399</u> exp. date: <u>12/08/13</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>M118735</u>								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*75345\***

Page 6

October-21-11 8:02:48 AM

Item ID: D350-636-015 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube STD w/ Training Wearplates, LH  
 Start Date: 20/10/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 02/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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10-Grind welds flush as per Dwg D4168

11-Spot face ground handling holes section (total of 4 places per side) as per  
 dwg D4168, section AL-AL

12- C'bore section CG-CG

13- Deburr holes

\*\*\*\*\* FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING  
 HOLE IN TUBE \*\*\*\*\* **NO**

170

QC10- Inspect visual per QSI004- ground welds 0.00

**\*170\***

QC

Memo

0.00

Quality Control

*S u l l i z i*

*11-01-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*75345\***

Page 7

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Item ID: D350-636-015 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube STD w/ Training Wearplates, LH  
 Start Date: 20/10/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 02/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	QC5- Inspect part completeness to step on W/O	0.00							
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**\*180\***

QC Memo

Quality Control

190	Pressure Wash per QSI005 4.3	0.00							
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**\*190\***

HandFinish Memo

Hand Finishing Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
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**\*200\***

Powdercoat Memo

Powder Coating

START TIME: 1:45  
 OVEN TEMPERATURE: 3200F  
 FINISH TIME: 2:15

M 118439

8 u / 11/21

1X Ø M-L 11/11/21

1X Ø M-L 11/11/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 75345

**\*75345\***

Page 8

October-21-11 8:02:48 AM

Item ID: D350-636-015 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube STD w/ Training Wearplates, LH  
 Start Date: 20/10/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 02/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00							
<b>*210*</b>						1			BL 11-11-22
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								
220		0.00							
<b>*220*</b>	HandFinishing					1			BL 11-11-22
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D4168								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 75345**

October-21-11 8:02:48 AM

**\*75345\***

Page 9

Item ID: D350-636-015

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

0.00

**\*230\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N/A.

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168

SIKA FLEX 241

BATCH: 119345EXP DATE: 12-1

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 1103455-Coat all exposed fasteners with "LPS Procyon" batch: 114596

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

tl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 75345****\*75345\***

Page 10

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Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011 Start Qty: 1.00

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

If making a D350-636-215  
pick kit will only requires:  
1 X AN3C37A  
1 X AN3C34A  
1 X AN3C42A  
2 X D3493-1

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-636-015

Location: \_\_\_\_\_

PPP rev: A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 75345****\*75345\***

Page 11

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Revision ID:

Stop **\*NS2\***

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011 Start Qty: 1.00

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Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

CK 11/11/25

ME  
11-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:52 AM

Page 1

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC  
11.04.14 ecn11-553 DD verf:EC  
NCR 11-906 DD verf:EC

IPP Rev:B  
IPP-Rev:C 11.10.18 as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3C34A		Purchased	No			230	Each	66.0000	1	1			
<b>*AN3C.34A*</b>									<b>**</b>				
BOLT													

Location	Loc Qty	Loc Code
ST353	66	
116075 ✓	42	
117514	20	
118838	4	

AN3C36A		Purchased	No			230	Each	156.0000	4	4			
<b>*AN3C.36A*</b>									<b>**</b>				
BOLT													

Location	Loc Qty	Loc Code
FG 118757	14	
101261	4	
116590	10	
ST353	142	
116590	0	
119083	12	
119125	30	
119324	100	

11-11-25

11-11-25

4.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

October-21-11 8:02:52 AM

Page 2

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C37A

Purchased

No

230

Each

139.0000

1

1

**\*AN3C37A\***

BOLT

\*\*

SP

Location

Loc Qty

Loc Code

ST354

139

116874

11

117010

2

118518

51

118709

50

119324

25

AN3C42A

Purchased

No

230

Each

45.0000

1

1

**\*AN3C42A\***

BOLT

\*\*

SP

Location

Loc Qty

Loc Code

ST354

45

106176

2

117763

20

118131

20

118451

3

D3492-1

Manufactured

No

230

Each

158.0000

8

8

**\*D3492-1\***

Plug

\*\*

B/L 11-11-25

Location

Loc Qty

Loc Code

FP

158

69531

8

73402

70

74444 ✓

80

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:52 AM

Page 3

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-3 Manufactured No

230 Each 117.0000 8 8

**\*D3492-3\***

Plug

\*\*

BR 11-11-25

Location

Loc Qty

Loc Code

FP

117

71838

37

74447

80

D3873-1 Manufactured No

230 Each 356.0000 7 7

**\*D3873-1\***

Bushing

\*\*

BR 11-11-25

Location

Loc Qty

Loc Code

ST088

356

64760

1

68247

4

73829

19

73831

332

D4154-041 Manufactured No

230 Each 4.0000 1 1

**\*D4154-041\***

Wearplate Assembly

\*\*

BR 11-11-25

Location

Loc Qty

Loc Code

FP

4

71442

4

D4170-1 Manufactured No

230 Each 36.0000 4 4

**\*D4170-1\***

Bushing

\*\*

BR 11-11-23

Location

Loc Qty

Loc Code

LG

32

68225

1

71844

31

LG002

4

65912

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:52 AM

Page 4

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4171-1 Manufactured No

230 Each 10.0000 1 1

**\*D4171-1\***

Bushing

\*\*

*11-11-25*

Location

Loc Qty

Loc Code

ST135

10

69037 ✓

10

MS21043-3 Purchased No

230 Each 921.0000 4 4

**\*MS21043-3\***

Nut

\*\*

*11-11-25*

Location

Loc Qty

Loc Code

FG

72

.103691

72

ST301

849

118077 ✓

1

118614 ✓

492

~~118086~~ ✓

356

NAS1149C0363R Purchased No

230 Each 3,939.000 8 8

**\*NAS1149C0363R\***

Washer

\*\*

*11-11-25*

Location

Loc Qty

Loc Code

ST297

3939

114742 ✓

3939

NAS1515H3L Purchased No

230 Each 111.0000 4 4

**\*NAS1515H3L \***

WASHER

\*\*

*11-11-25*

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

71

113362 ✓

57

118686 ✓

14

October-21-11 8:02:52 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:52 AM

Page 5

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

105.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

BR 11-11-25

Location

Loc Qty

Loc Code

FP

117460

81

118077

8

118612

1

110915

72

FP-A

24

119307

14

119307

10

NAS1611-013

Purchased

No

230

Each

192.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

BR 11-11-25

Location

Loc Qty

Loc Code

FP

117291

55

117887

2

116582

53

FP-A

137

118384

5

119307

32

119307

100

NAS1149D0863J

Purchased

No

250

Each

230.0000

2

2

**\*NAS1149D0863.J\***

WASHER

\*\*

BR 11-11-25

Location

Loc Qty

Loc Code

ST298

230

118078

130

119307

100

October-21-11 8:02:52 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

October-21-11 8:02:52 AM

Page 6

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2744 Manufactured No

110 Each 63.0000 1 1

**\*D2744\***

Cap

\*\*

BE 11-11-15

Location Loc Qty Loc Code

LG002 13

62715 1

70881 12

WA 50

71861 50

D2600-3-BENT Manufactured No

110 Each 41.0000 1 1

**\*D2600-3-BENT\***

Extrusion Bent

\*\*

Wk 12/11/15

Location Loc Qty Loc Code

LG 41

66875 8

73253 3

75021 10

75022 10

75023 10

D2743 Manufactured No

160 Each 201.0000 8 8

**\*D2743\***

Crossbolt Spacer

\*\*

BE 11-11-18

Location Loc Qty Loc Code

LG 143

71839 79

73403 64

LG001 58

67766 4

68251 54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:53 AM

Page 7

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No

160 Each 9.0000 1 1

**\*D2739\***

350 I Beam

\*\*

Location 76140 Loc Qty Loc Code

LG 9

72155 2

72156 3

72157 4

D3490-3 Manufactured No

160 Each 42.0000 4 4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

Location Loc Qty Loc Code

LG 42

73295 42

D3490-1 Manufactured No

160 Each 42.0000 4 4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

Location Loc Qty Loc Code

LG 40

67773 5

71841 35

LG001 2

62450 2

October-21-11 8:02:53 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:53 AM

Page 8

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

2,610.000

4

4

**\*AI S4-1032-225\***

Insert

\*\*

BR 11-11-25

Location

Loc Qty

Loc Code

ST282

2610

108696

758

110768

62

118386

860

118966 ✓

930

AN8C35A

Purchased

No

230

Each

113.0000

1

1

**\*AN8C35A\***

BOLT

\*\*

BR 11-11-25

Location

Loc Qty

Loc Code

FP

77

117511

11

118286 ✓

66

FP-A

1

115960

1

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:53 AM

Page 9

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

18.0000

1

1

**\*D3488-041\***

Blade Fitting Assembly, LH

\*\*

*DR 11-11-05*

Location

Loc Qty

Loc Code

FP

*75056.*

8

69903

8

FP007

1

61689

1

FP008

9

67788

1

71887

8

AN6C44A

Purchased

No

230

Each

113.0000

4

4

**\*AN6C44A\***

BOLT

\*\*

*BR 11-11-05*

Location

Loc Qty

Loc Code

FG

*119530*

2

103964

2

ST343

111

118387

41

118985

40

119125

30

*4.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

October-21-11 8:02:53 AM

Page 10

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

92.0000

1 1

**\*MS21083C8\***

NUT

\*\*

*DR 11-11-25*

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

6

118077

6

ST303

85

115884

0

118354

10

118614 ✓

50

119309

25

D3631-1

Manufactured

No

230

Each

107.0000

8

8

**\*D3631-1\***

Washer

\*\*

*DR 11-11-25*

Location

Loc Qty

Loc Code

ST072

107

68062 ✓

107

AN960C10L

NAS1149C0332 ✓  
R

Purchased

No

230

Each

0.0000

4

4

**\*AN960C10L \***

washer

D2745

Manufactured

No

230

Each

165.0000

8

8

**\*D2745\***

Bushing

\*\*

*DR 11-11-25*

Location

Loc Qty

Loc Code

FP-A

3

69529

3

ST021

162

71835 ✓

162

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:53 AM

Page 11

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

345.0000

1

1

**\*NAS1149C0832R\***

WASHER

\*\*

*BR 11-11-25*

## Location

## Loc Qty

## Loc Code

FP-B

17

114915 ✓

17

ST297

328

114915

328

AN3C6A

Purchased

No

230

Each

232.0000

4

4

**\*AN3C6A\***

BOLT

\*\*

*BR 11-11-25*

## Location

## Loc Qty

## Loc Code

FP-A

1

111982

1

ST351

231

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

176

*4.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:53 AM

Page 12

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

505.0000

4

4

\*\*

**\*MS21043-6\***

NUT

*BK 11-11-25*

## Location

## Loc Qty

## Loc Code

FG

20

103693

20

ST301

485

112314 ✓

275

117887

10

118384

200

*4.*

D3493-1

Manufactured

No

250

Each

55.0000

2

2

\*\*

**\*D3493-1\***

Washer

*[Signature]*

## Location

## Loc Qty

## Loc Code

ST062

55

70697

17

71846

38

*2*

MS21083C8

Purchased

No

250

Each

92.0000

2

2

\*\*

**\*MS21083C8\***

NUT

*[Signature]*

## Location

## Loc Qty

## Loc Code

FP-B

1

115884

1

ST293

6

118077

6

ST303

85

115884

0

118354

10

118614

50

~119309

25

*2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-21-11 8:02:53 AM

Page 13

Work Order ID: 75345

**\*75345\***

Parent Item: D350-636-015

**\*D350-636-015\***

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

69.0000

2

2

\*\*

**\*AN8C21A\***

BOLT

Location

Loc Qty

Loc Code

ST343

69

118045

19

118758

50

Manufactured

No

250

Each

19.0000

1

1

\*\*

D2741

**\*D2741\***

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

19

70667

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149C0363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149C0332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149C0832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 75345 M.L.J  
11/10/21

RELEASED  
2010-09-15

A	NEW ISSUE	DESCRIPTION	SC	10.08.09
REV.			BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.		
DRAWN	SC	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4168	SHEET 1 OF 11	
APPROVED		TITLE	SCALE	
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS	
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

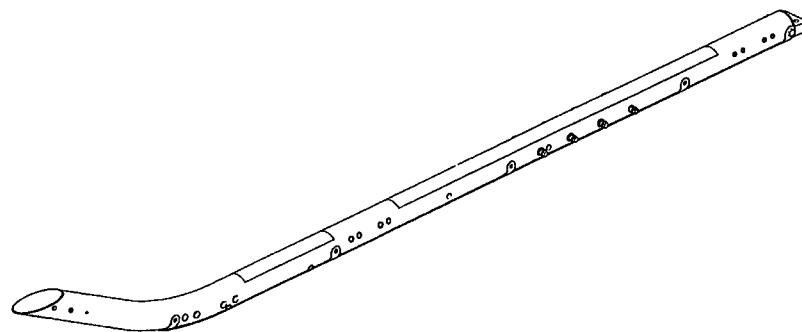
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

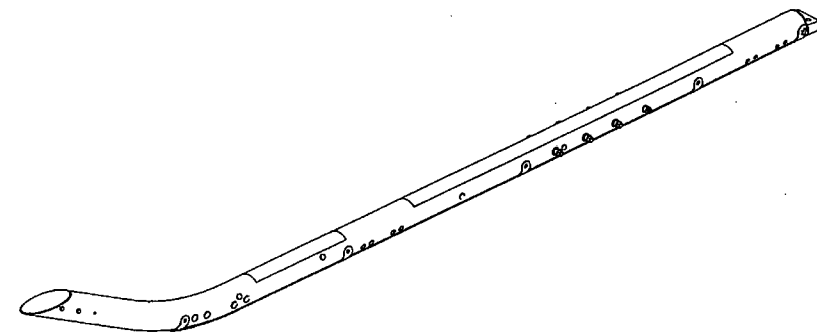
**NOTE:** Date & initial all entries

b7E 0000

75345



**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

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2010-09-15  
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DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING I/O.	REV. A
MFG. APPR.		<b>D4168</b>	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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# Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

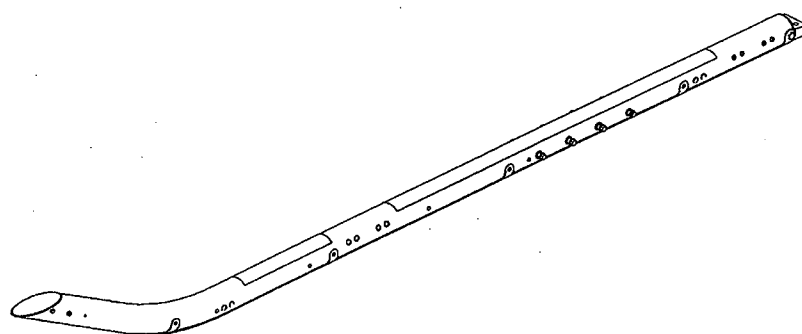
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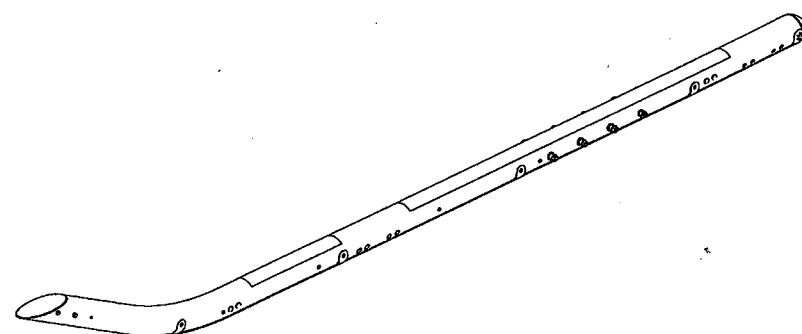
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**D4168-043 350 SKIDTUBE ASSEMBLY, LH**



**D4168-044 350 SKIDTUBE ASSEMBLY, RH**

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2010-09-15

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4168</b>	SHEET 3 OF 11
APPROVED		TITLE	SCALE
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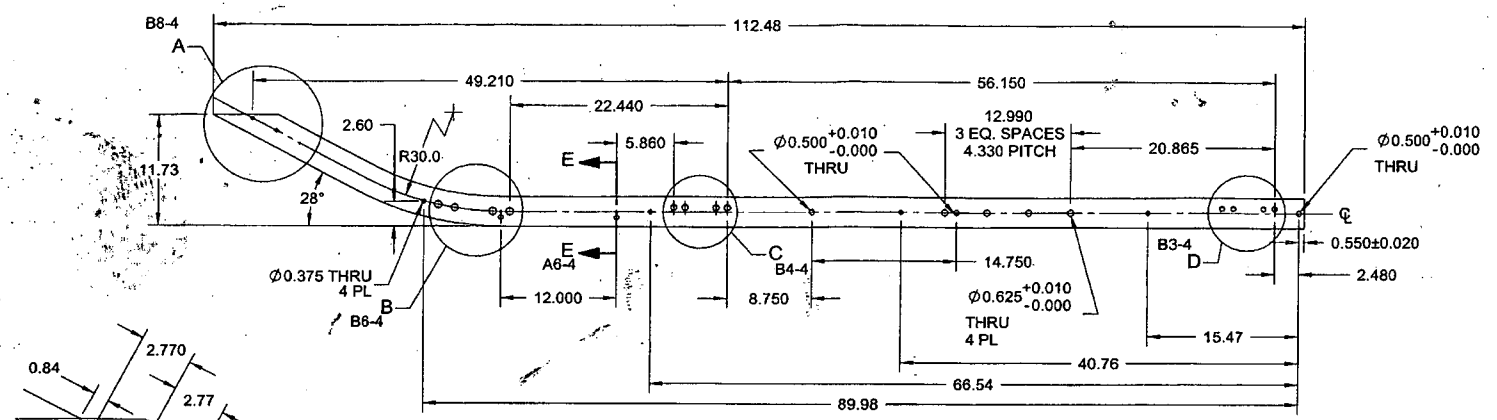
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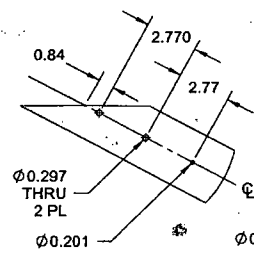
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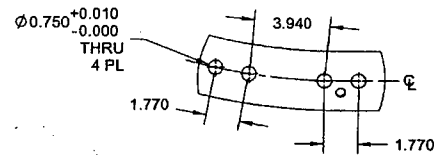
78345



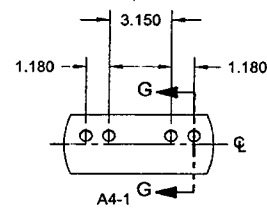
**D4168-1 LH SKIDTUBE**



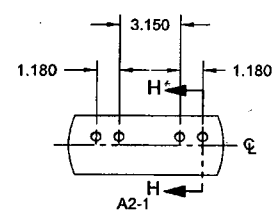
**DETAIL A**  
SCALE 2X



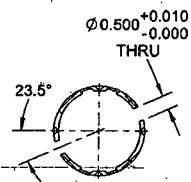
**DETAIL B**  
SCALE 2X



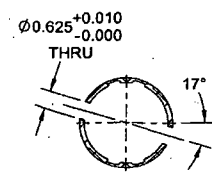
**DETAIL C**  
SCALE 2X



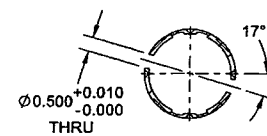
**DETAIL D**  
SCALE 2X



**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.		<b>D4168</b>	SHEET 4 OF 11
APPROVED		TITLE	SCALE
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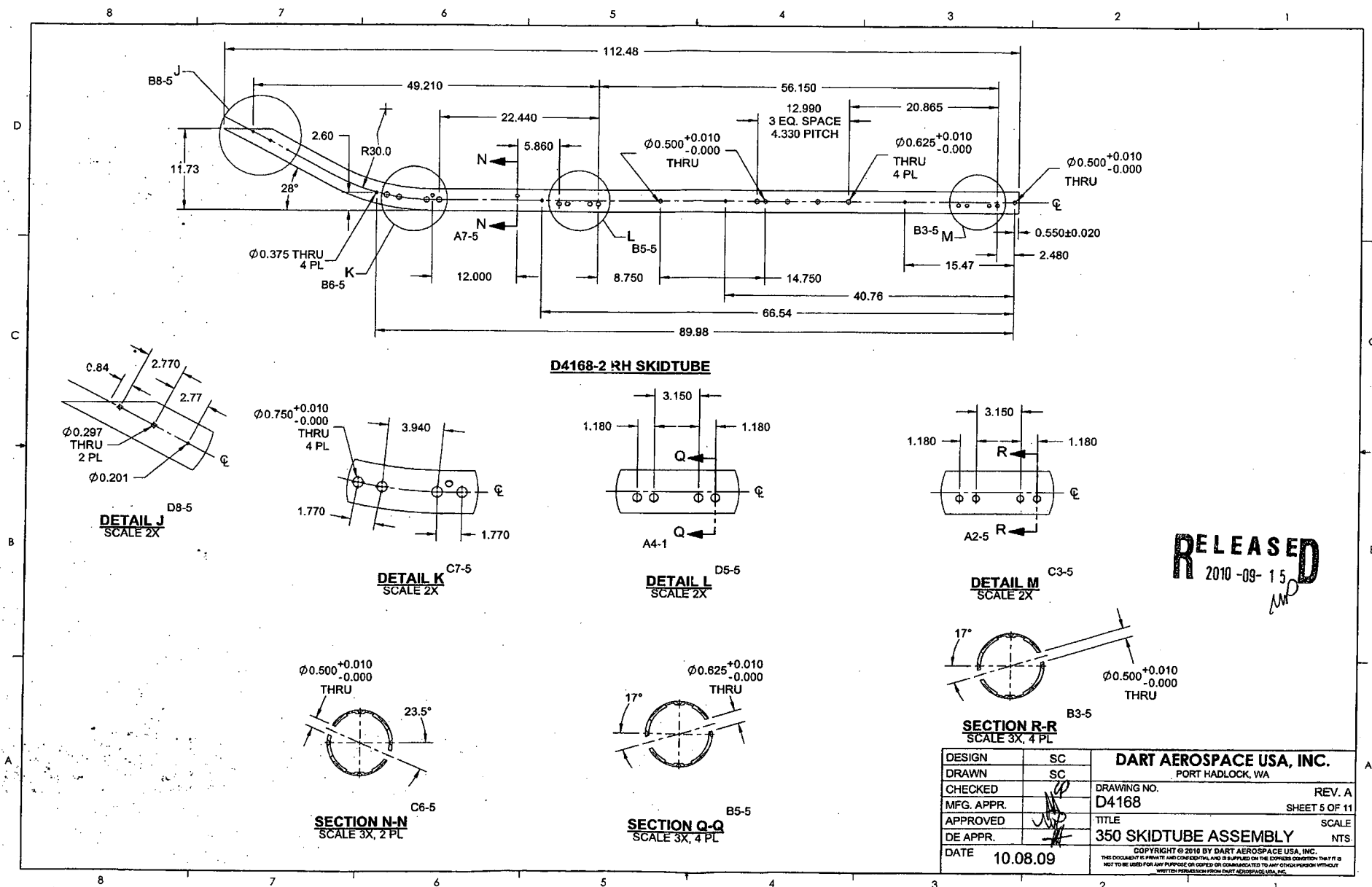
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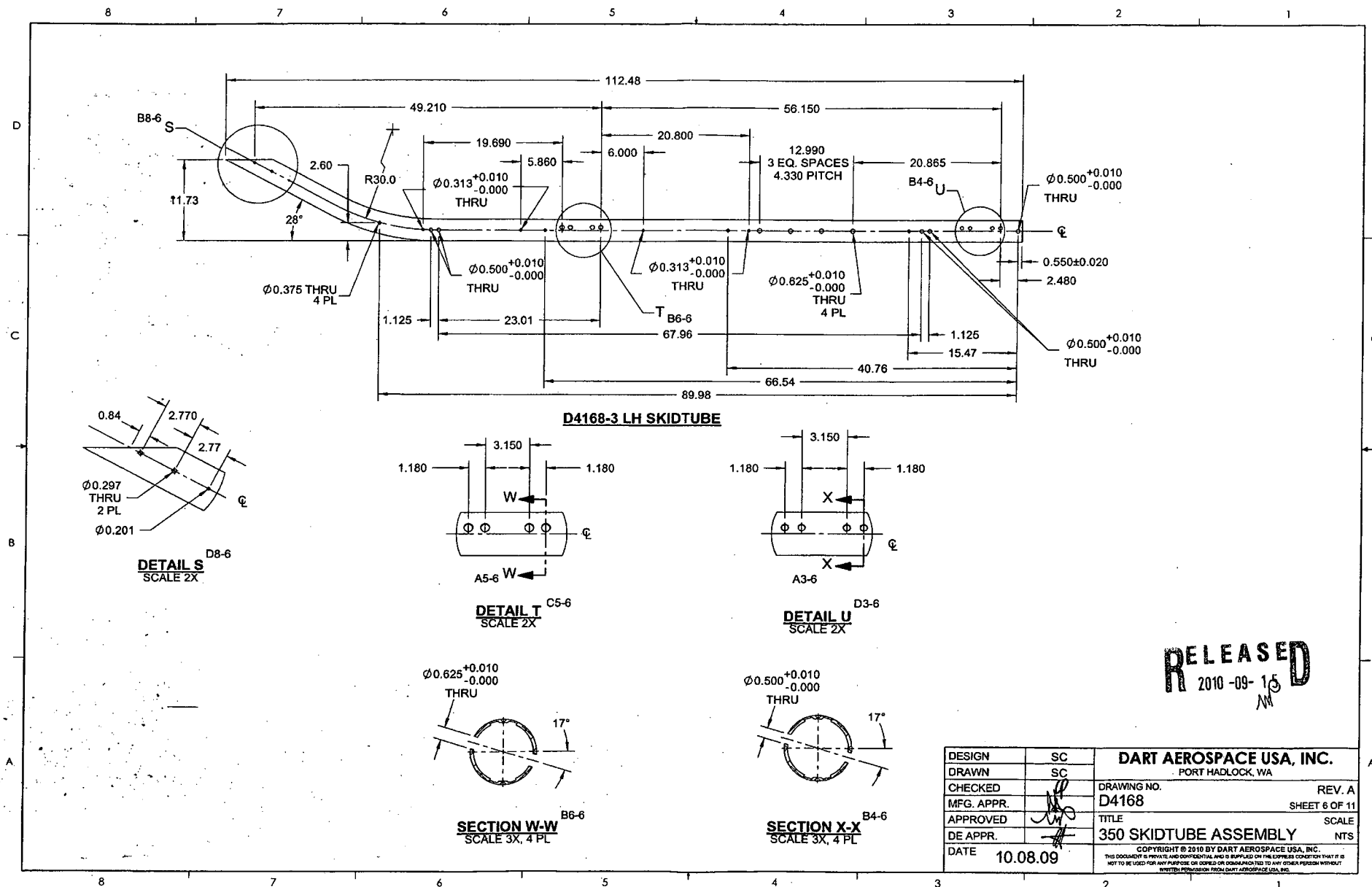
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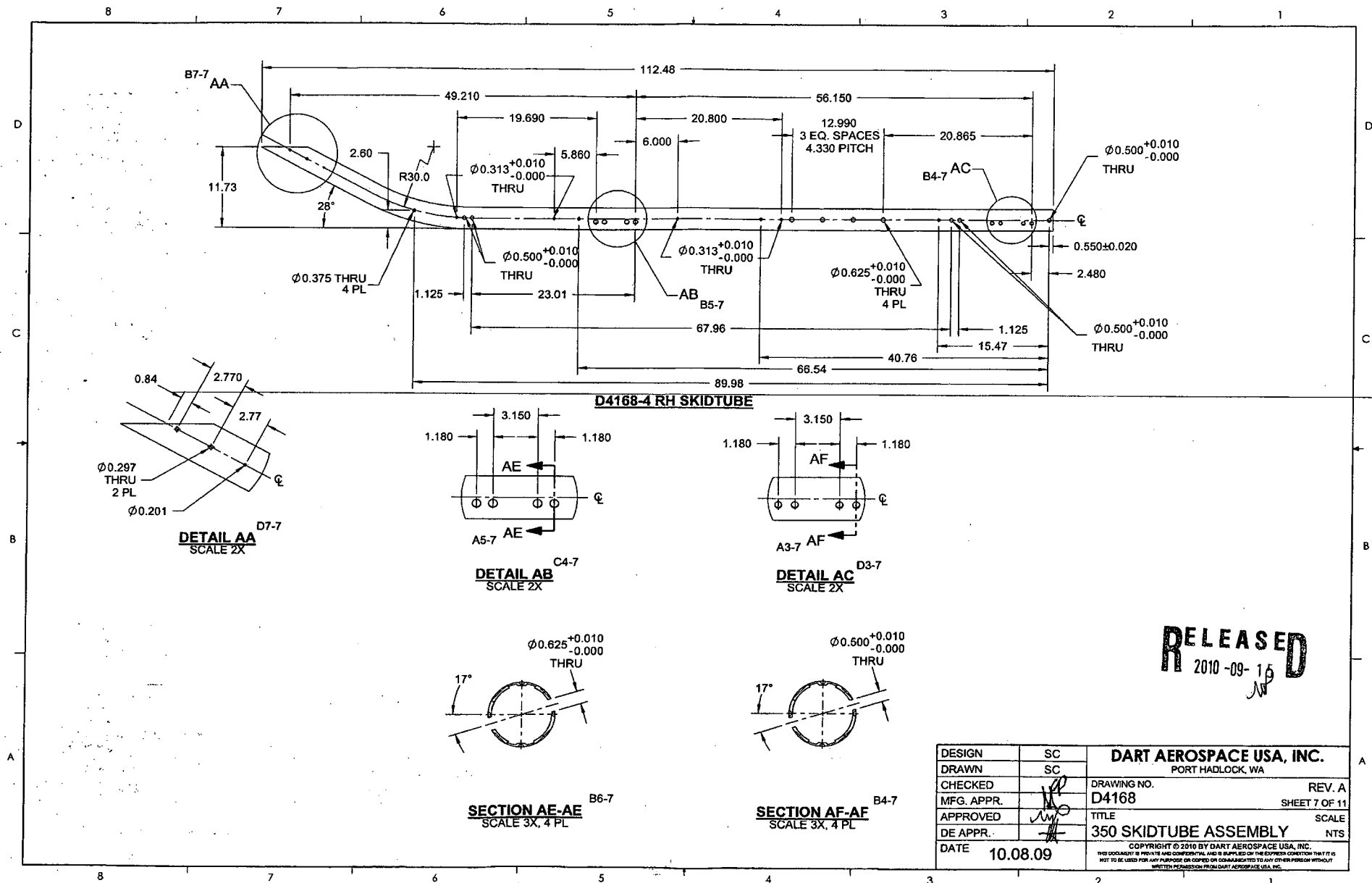
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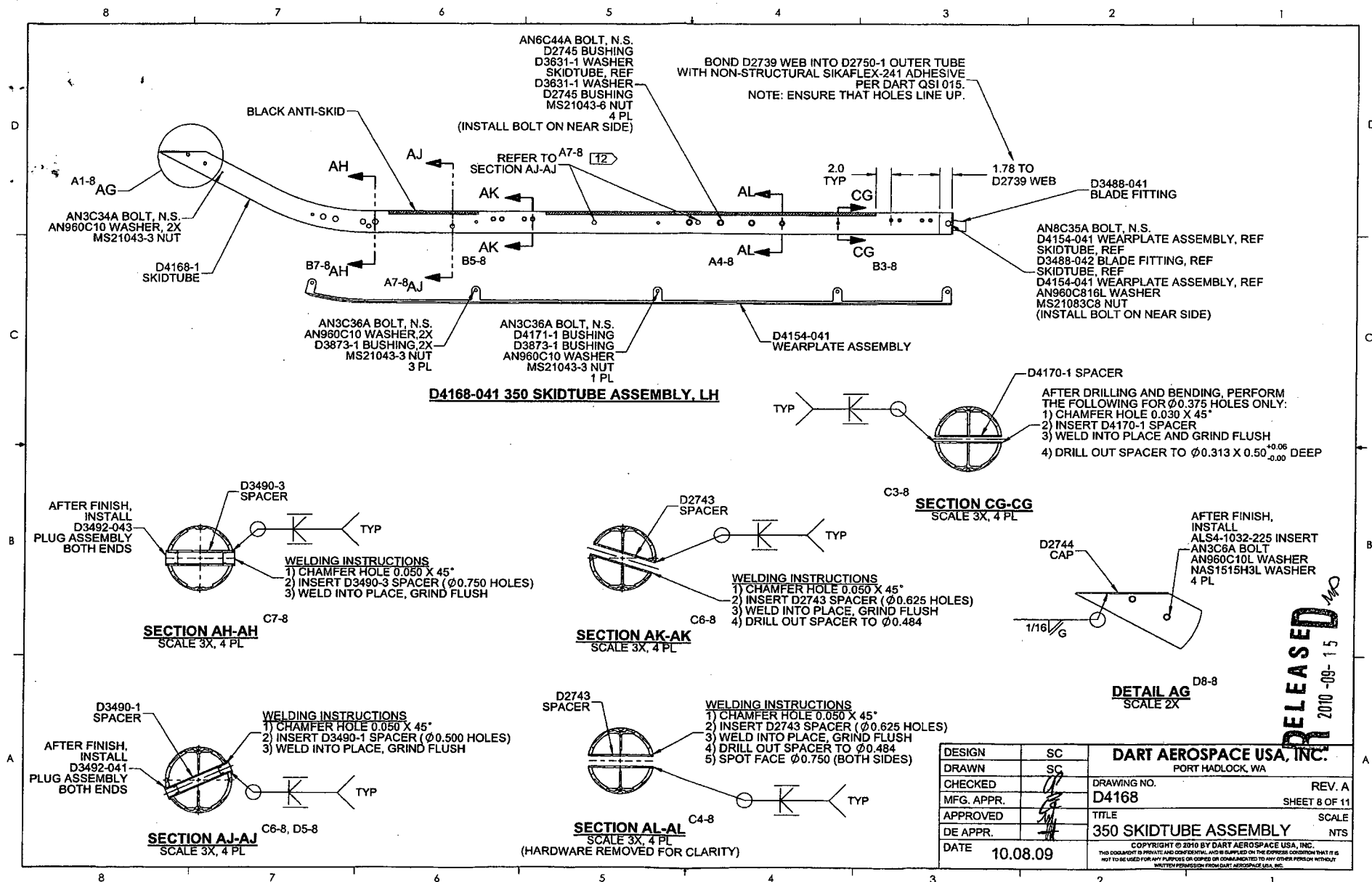
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

D

A1-9 AM

AN3C34A BOLT, F.S.  
AN960C10 WASHER, 2X  
MS21043-3 NUT

D4168-2 SKIDTUBE

BLACK ANTI-SKID

AN

AP

AQ

A7-9

B7-9

B5-9

AN3C36A BOLT, F.S.  
AN960C10 WASHER, 2X  
D3873-1 BUSHING, 2X  
MS21043-3 NUT  
3 PL

AN3C36A BOLT, F.S.  
D4171-1 BUSHING  
D3873-1 BUSHING  
AN960C10 WASHER  
MS21043-3 NUT  
1 PL

D4154-041 WEARPLATE ASSEMBLY

AN8C44A BOLT, F.S.  
D2745 BUSHING  
D3631-1 WASHER  
SKIDTUBE, REF  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT  
4 PL  
(INSTALL NUT ON NEAR SIDE)

REFER TO SECTION AP-AP

A7-9

BOND D2739 WEB INTO D2750-2 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015. NOTE: ENSURE THAT HOLES LINE UP.

2.0 TYP

CH

1.78 TO D2739 WEB

D3488-042 BLADE FITTING

AN8C35A BOLT, F.S.  
D4154-041 WEARPLATE ASSEMBLY, REF SKIDTUBE, REF  
D3488-042 BLADE FITTING, REF SKIDTUBE, REF  
D4154-041 WEARPLATE ASSEMBLY, REF AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL NUT ON NEAR SIDE)

A5-9 AR

CH

B3-9

D4170-1 SPACER

D4168-042 350 SKIDTUBE ASSEMBLY, RH

TYP

C3-9

SECTION CH-CH  
SCALE 3X, 4 PL

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR  $\phi 0.375$  HOLES ONLY:  
1) CHAMFER HOLE  $0.030 \times 45^\circ$   
2) INSERT D4170-1 SPACER  
3) WELD INTO PLACE AND GRIND FLUSH  
4) DRILL OUT SPACER TO  $\phi 0.313 \times 0.50^{+0.05}_{-0.00}$  DEEP

D2744 CAP

D8-9

DETAIL AM  
SCALE 2X

1/16 G

AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY BOTH ENDS

SECTION AN-AN  
SCALE 3X, 4 PL

C7-9

WELDING INSTRUCTIONS  
1) CHAMFER HOLE  $0.050 \times 45^\circ$   
2) INSERT D3490-3 SPACER ( $\phi 0.750$  HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY BOTH ENDS

SECTION AP-AP  
SCALE 3X, 4 PL

C6-9, D5-9

WELDING INSTRUCTIONS  
1) CHAMFER HOLE  $0.050 \times 45^\circ$   
2) INSERT D3490-1 SPACER ( $\phi 0.500$  HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

D2743 SPACER

SECTION AQ-AQ  
SCALE 3X, 4 PL

C5-9

WELDING INSTRUCTIONS  
1) CHAMFER HOLE  $0.050 \times 45^\circ$   
2) INSERT D2743 SPACER ( $\phi 0.625$  HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO  $\phi 0.484$   
5) SPOT FACE  $\phi 0.750$  (BOTH SIDES)

SECTION AR-AR  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

C4-9

DESIGN SC  
DRAWN SC  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 10.08.09

SC  
SC  
SC  
SC  
SC  
SC

DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

DRAWING NO.  
D4168

TITLE  
350 SKIDTUBE ASSEMBLY

REV. A  
SHEET 9 OF 11  
SCALE  
NTS

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2010-09-15

1

B

A

8 7 6 5 4 3 2 1

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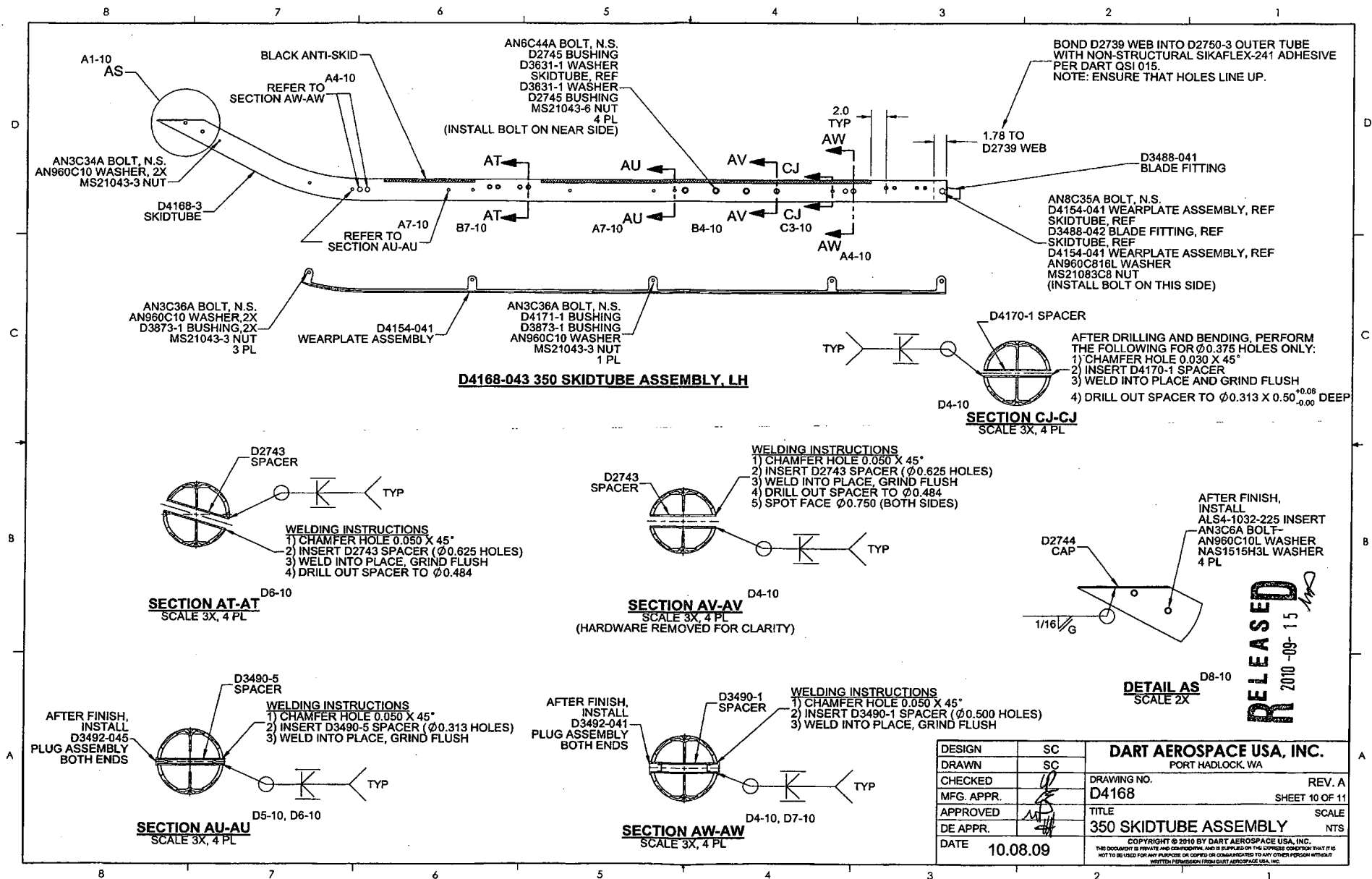
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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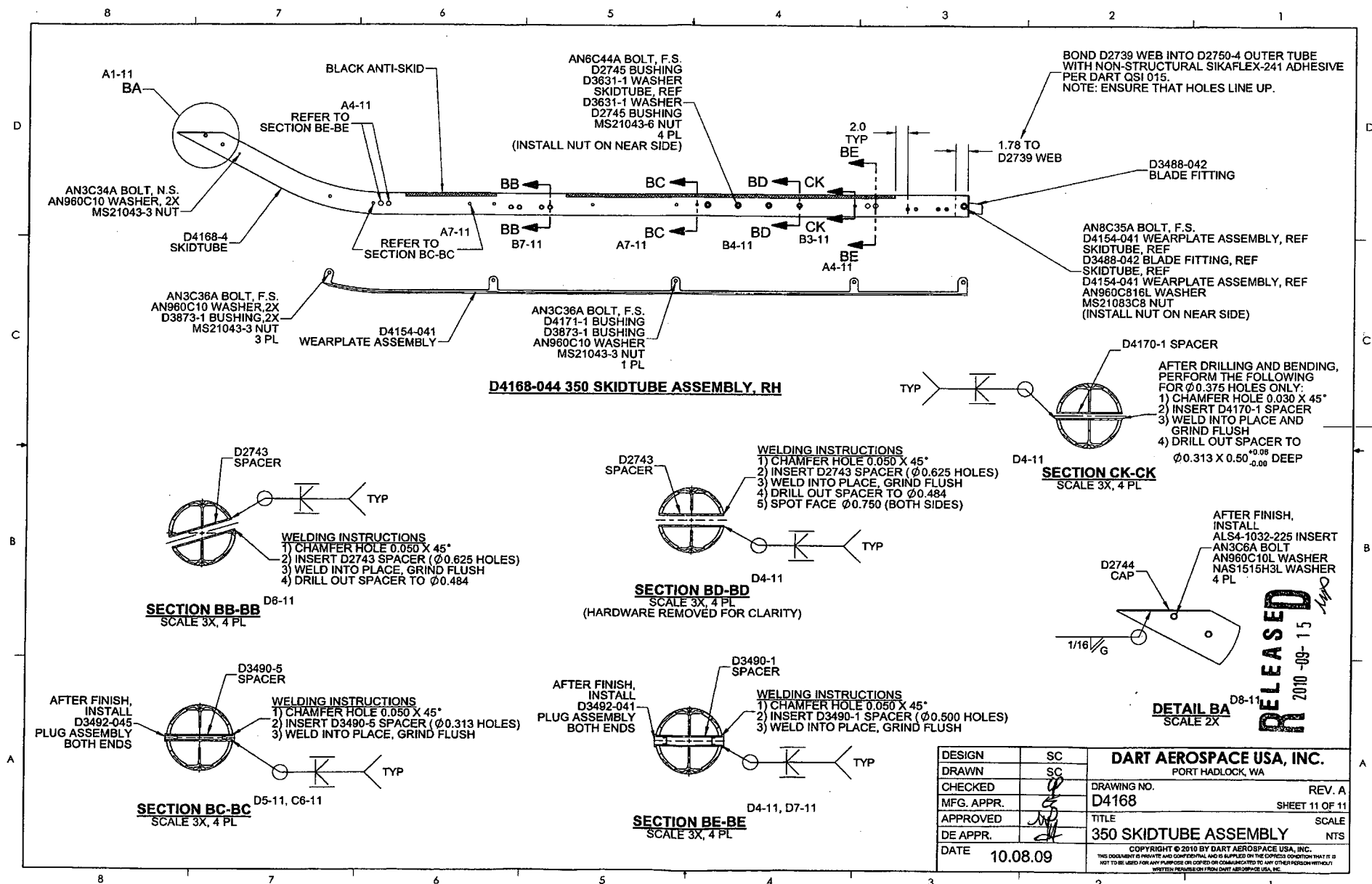
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**NOTE:** Date & initial all entries

NO. 270

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: B 72821  
Part number: D 350 636 D12  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Dunn Date of Test Coupon 11-10-07  
Welder Barclay Elliott Date of Test Coupon 11-10-07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld